

Work Order ID 56533



Page 1

March 1, 2010 9:42:13 AM

Item ID: D3564-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *U* QC: *U*Date: Tooling: Date:
Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3564	Rev D								

100 0.00



FLOW WATER JET

Waterjet

Memo 0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 Dwg Rev: *D* Prog Rev: *D* 2-
Deburr if necessary*304.063**HB 10-3-9*

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo 0.00

Quality Control

HB 10-3-9

120 0.00



QC8- Inspect parts - second check

QC

Memo 0.00

Quality Control

*5/10/09**(718)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56533

March 1, 2010 9:42:13 AM



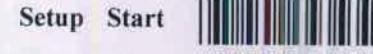
Page 2

Item ID: D3564-13

Accept



Setup



Start

Revision ID:

Item Name: Wearshoe



Stop

Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

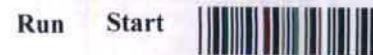
Approvals: Process Plan:

Date:

Tooling:

Date:

Run



Start

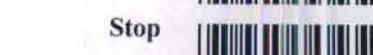
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

130



Operation Description

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

NC BRAKE

0.00

Brake NC

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179

80 10/03/17

18 6

140



QC5- Inspect part completeness to step on W/O

0.00

80 10/03/17

QC

Memo

0.00

(X10)

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=) 80 10/03/17

Powdercoat

Powder Coating

Memo

0.00

START TIME: 8:15AM OVEN TEMPERATURE:
8:45AM FINISH TIME: 3704

(X10) 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56533

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Item ID: D3564-13

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 3/01/10 Start Qty: 12.00



Required Date: 3/08/10 Req'd Qty: 12.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

BL

Draw
Rev.

10-3-22

Plan
Code

10

Accept
Qty

10

Reject
Qty

0

Reject
Number

10

Insp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-17 0.00

BL 10-3-22

10 0.

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/23

MP

10-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:42:12 AM

Page 1

Work Order ID: 56533



Parent Item: D3564-13



Parent Item Name: Wearshoe

Comments: IPP Rev:A New Issue 07-03-08 ec

Start Date: 3/01/10

Required Date: 3/08/10

IPP Rev:B As per Rev C 07-07-09 JLM

Start Qty: 12.00

Required Qty: 12.00

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ

M304S16GA



Purchased No

100 sf 179.8899 2.8042

4.5

304/316 Sheet .063

JB 10-3-9

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	179.8898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	116.8049	

18

113295

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56533
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	AB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-9	Date:	10/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	
C	08.02.28	Dwg Rev updated	KJ/DD	 

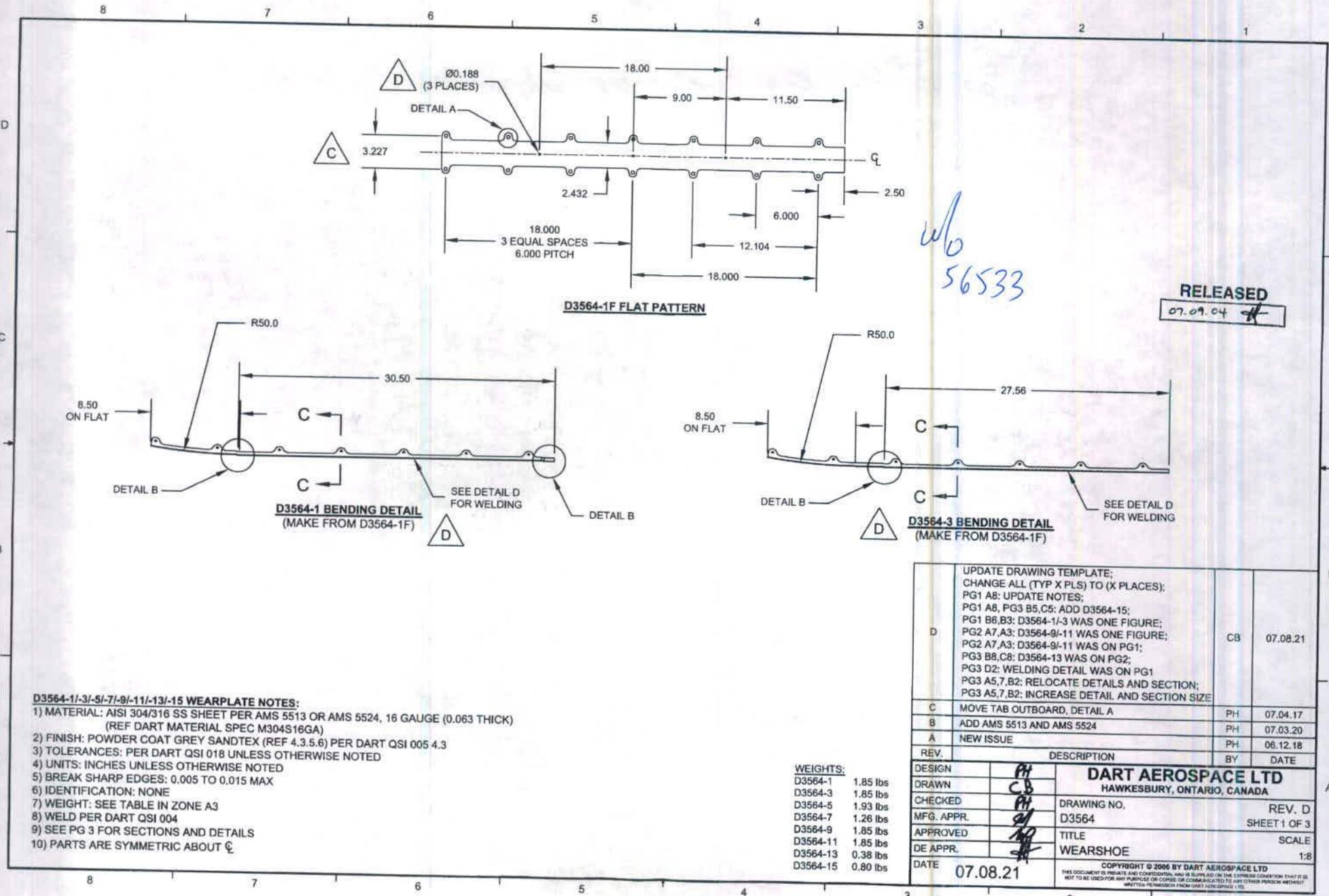
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

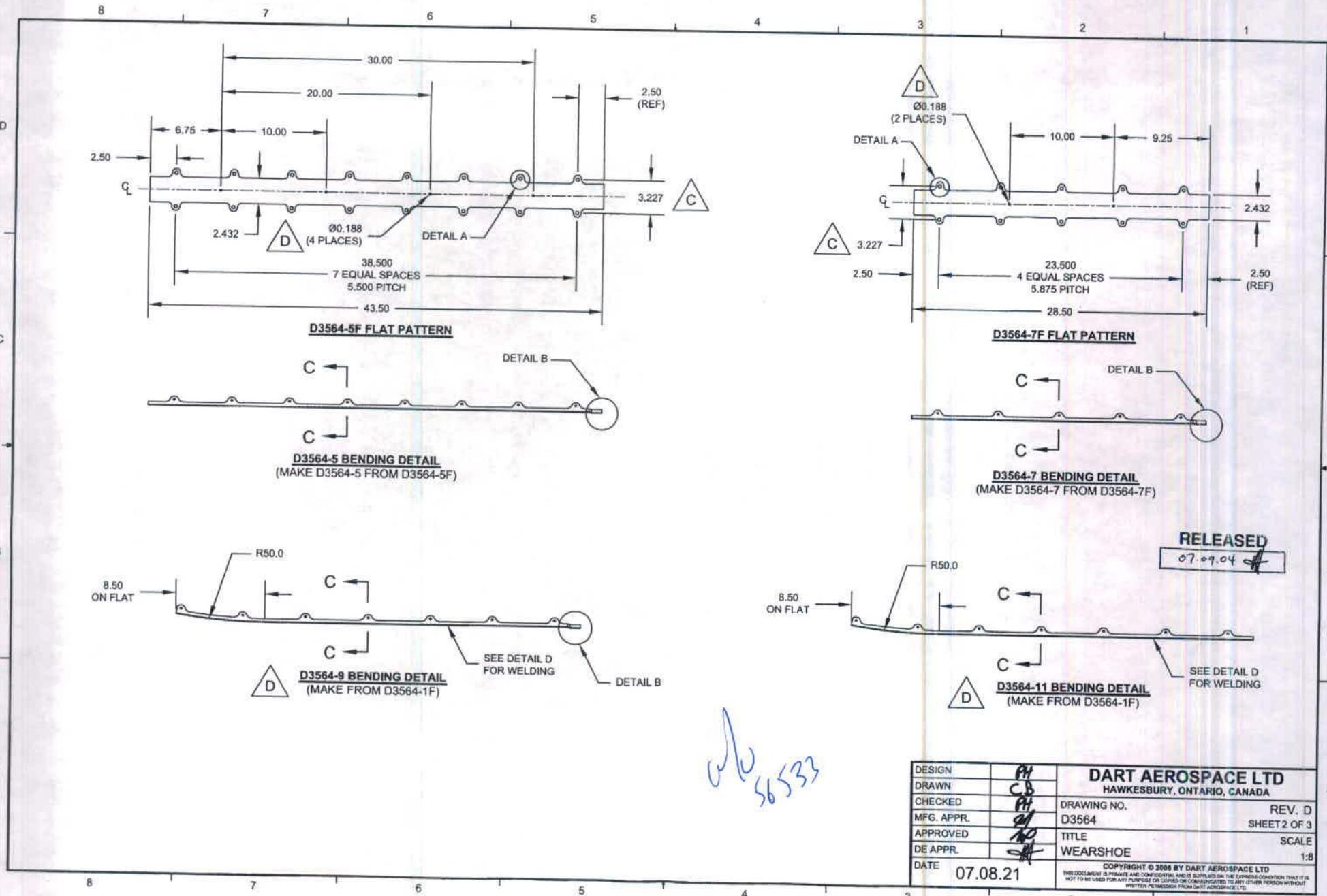
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

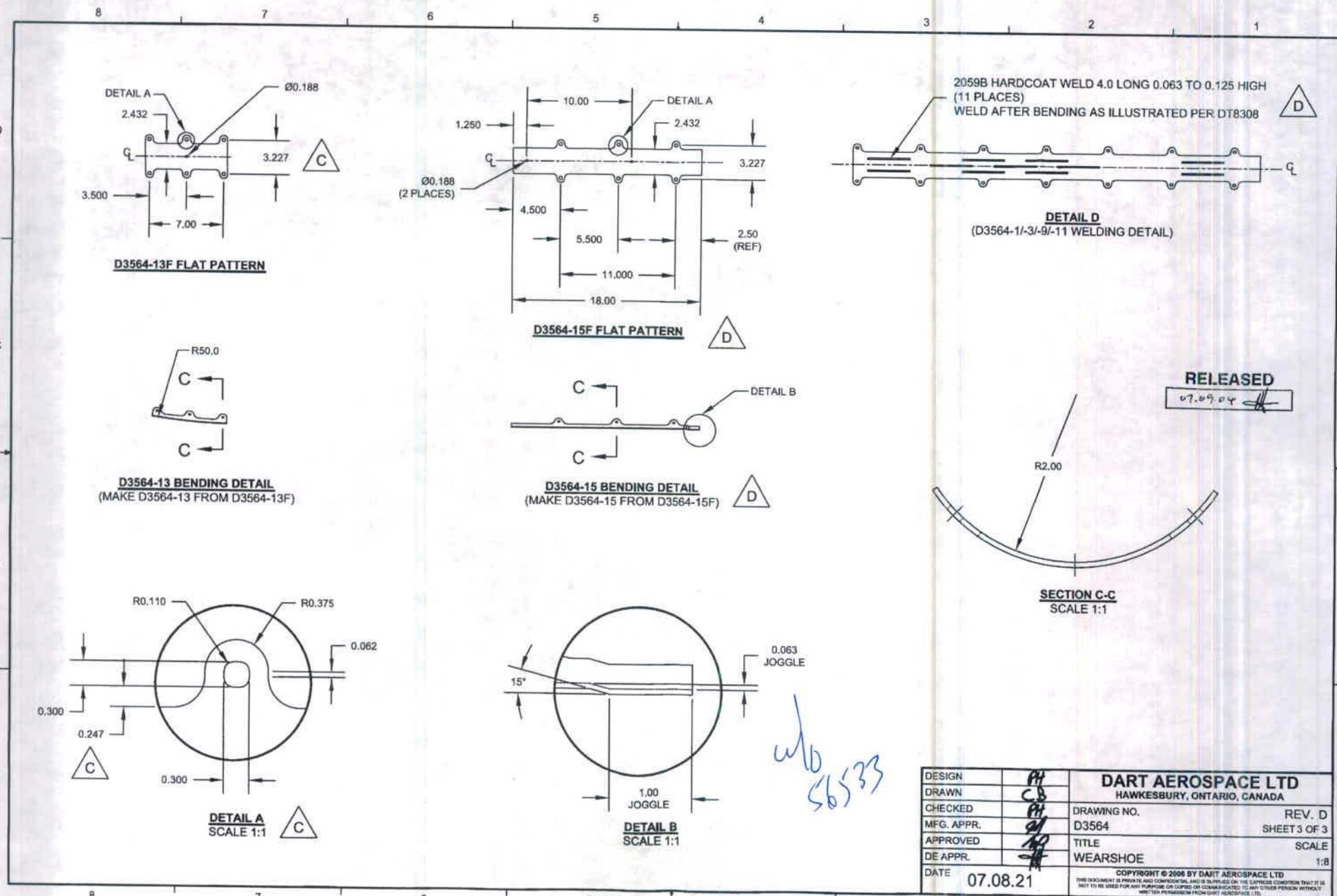
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NOTE: Date & initial all entries









DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3564
MFG. APPR.	SH	REV. D
APPROVED	SH	SHEET 3 OF 3
DE APPR.	SH	SCALE 1:8
DATE	07.08.21	WEARSHOE

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